

Work Order ID 135785

August 20, 2015 9:30:57 AM

647.7703
B105785
REV. A

135785

Kush

Page 1

Item ID: 647.7703

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Strut Assembly

Start Date: 8/20/2015 Start Qty: 6.00

6
8 10 *[Signature]*

Cust Item ID:

Required Date: 9/3/2015 Req'd Qty: 6.00

Customer:

Reference:

Approvals: Process Plan: *SM* Date: *20150820*

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

647.7700

A

110

Pick Kit

0.00

110

Packaging

Memo

0.00

Packaging

10

15-08-21

JBL

120

Weld per dwg A/R 4130 rod Batch *120925*

0.00

120

Large Fab

Memo

0.01

Large Fab

1- ASSEMBLE AND WELD AS PER DWG

***IMPORTANT DIMENSION IS 8.35" ***

15-08-24

JBL

130

QC9- Inspect visual per QSI004- Fusion Welds

0.00

130

QC

Memo

0.00

Quality Control

10

15-8-28

DAS
50
9-89

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :				MRB (QSI042) Approval	
Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER :							
Misidentified ☐	Past Due ☐								

August 20, 2015 9:30:57 AM

Item ID: 647.7703

Accept

N900040100

Setup Start *NS1*

Revision ID:

Item Name: Strut Assembly

Stop *NS2*

Start Date: 8/20/2015 **Start Qty:** 6.00

6

Cust Item ID:

Required Date: 9/3/2015 **Req'd Qty:** 6.00

6

Customer:

Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140	QC5- Inspect part completeness to step on W/O	0.00							DAS
140						(10)			38
QC	Memo	0.00							9-89
						AUG 26 2015			

150	Outsource process-Cadplate per QSI017 4.1.9.1	0.00
150		
Outsource3	Memo	24.00
Outsource process - Cad plate	Issue P/O : <u>29626</u> C of C is required	

CG AUG 27 2015 10

160	Receive & Inspect for Damage & Mat'l Certs	0.00
160		
Packaging	Memo	0.00
Packaging		

SEP 04 2015

DAS
86
9-89

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width: 100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐																						
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Date :		Step #:		QTY Effective :			MRB (QSI042) Approval																		
Description Work Order Deviation				Disposition				Completed By																	
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Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐																				
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Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____																							
Misidentified ☐	Past Due ☐																								

Work Order ID 135785

135785

Page 3

August 20, 2015 9:30:57 AM

Item ID: 647.7703 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Strut Assembly
 Start Date: 8/20/2015 Start Qty: 6.00 ***6*** Cust Item ID:
 Required Date: 9/3/2015 Req'd Qty: 6.00 ***6*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
170	QC5- Inspect part completeness to step on W/O	0.00							
170									
QC	Memo	0.00							
Quality Control									
180		0.00							
180									
SprayPaint	Memo	0.00							
Spray Painting	PRIOR TO PRIME MASK THREAD AND PRIME AS PER DWG								
	PRIMER BATCH: <u>131277</u>								
190	QC14- Inspect Spray Paint	0.00							
190									
QC	Memo	0.00							
Quality Control									

(16) 1509-04 PD
 10 DAS 41 9-89 15-9-8
 (10) DAS 38 SEP 09 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
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Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐
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Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐
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Work Order ID 135785

135785

Page 4

August 20, 2015 9:30:57 AM

Item ID: 647.7703 Accept ***N900040100*** Setup Start ***NS1***
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 Required Date: 9/3/2015 Req'd Qty: 6.00 ***6*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
200	Identify as per dwg & Stock Location:	0.00				10	27		
200									
Packaging	Memo	0.00							
Packaging									
210	QC21- Final Inspection - Work Order Release	0.00							
210									
QC	Memo	0.01							
Quality Control									

SH 120150909

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐																						
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Root Cause		FAULT CATEGORY																							
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐	OTHER : ☐																			

August 20, 2015 9:31:29 AM

Work Order ID: 135785

Parent Item: 647.7703

Parent Item Name: Strut Assembly

135785

647 7703

Start Date: 8/20/2015

Required Date: 9/3/2015**Start Qty: 6.00**

Required Qty: 6.00

Comments: IPP REV:A 15.01.07 NEW ISSUE DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
647.7712 *647 7712* Strut Tube		Manufactured	No				Each	18.0000		6			
				<u>Location</u>			<u>Loc Qty</u>						
				CCK113			18						
				(134880)			18						
647.7713 *647 7713* Strut Thread		Manufactured	No				Each	14.0000		6			
				<u>Location</u>			<u>Loc Qty</u>						
				CCK113			14						
				(134905)			14						
647.7714 *647 7714* Strut Tube		Manufactured	No				Each	0.0000		6			
				<u>Location</u>			<u>Loc Qty</u>						
				CCK113			14						
				(134905)			14						

APICAL

INDUSTRIES, INC.

ENGINEERING CHANGE NOTICE NO.

04741

SHEET 1 OF 1

DWG NO. 647.7700

REV: NC

PREPARED BY

J. SOTO

DATE: 11/13/2014

EFFECT ON DWG
☒ INC. ☐ UNINC.

DWG TITLE: STRUT ASSY

APPROVED BY:

ENGR

MFG

QC

EFF. NEXT ORDER

TRANSACTION CODES (TC):
A-ADD C-CREATE
R-REVISE D-DELETE

REASON: CREATED NEW CONFIGURATION. ADDED F/N 5.

54 20150820
135 785

5	A	647.7714	1	STRUT TUBE	△	
4	R	647.7713	1	STRUT THREAD	△	△
3	R	647.7712	1	STRUT TUBE	△	
	C	647.7703	X	STRUT ASSY		
F/N	TC	PART NUMBER	.7703			
		QTY		DESCRIPTION	MATERIAL	SPECIFICATION
DOCUMENTS EFFECTED:				CHANGE CATEGORY		
				DER REVIEW REQUIRED		

☐ MDL ☐ INSTALL INSTRUCTIONS ☐ ICA ☐ FMS ☒ BOM

☐ MAJOR ☒ MINOR

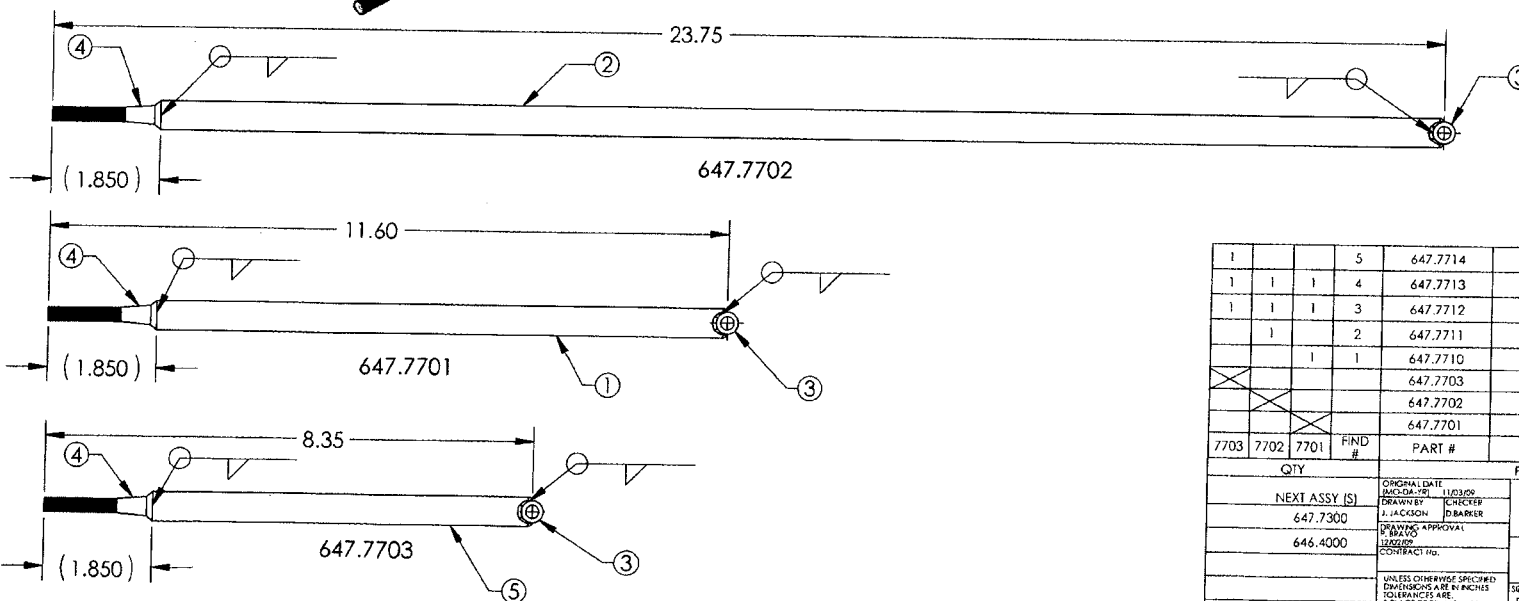
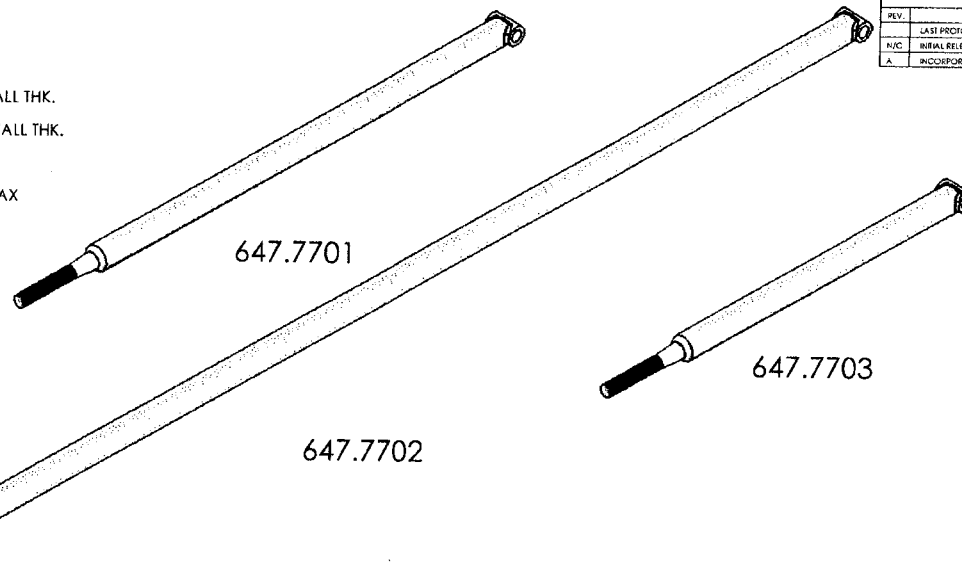
☐ YES ☒ NO

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NOTES:

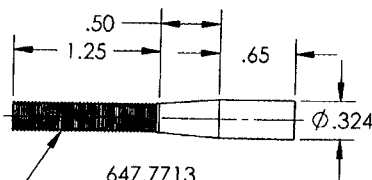
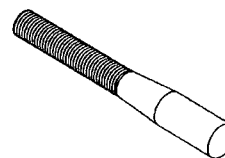
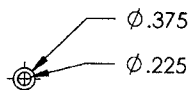
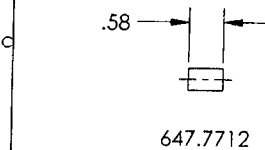
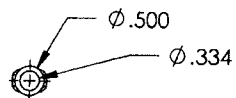
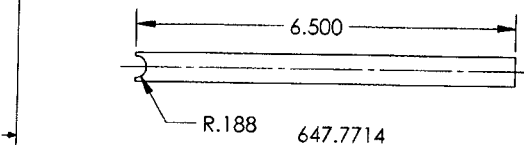
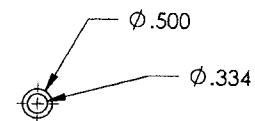
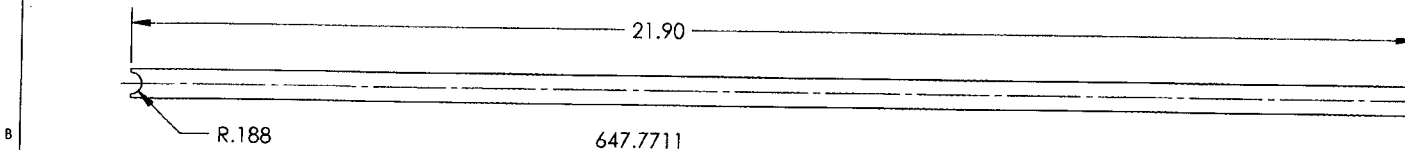
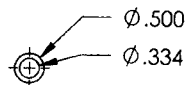
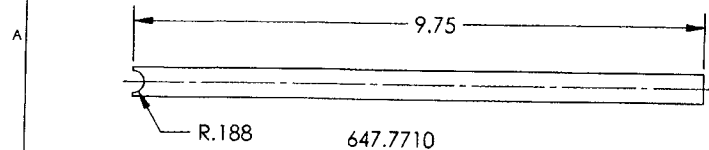
- 1 MATERIAL: 4130 STEEL PER AMS-T-6736, .50" OD, .083" WALL THK.
- 2 MATERIAL: 4130 STEEL PER AMS-T-6736, .375" OD, .075" WALL THK.
- 3 MATERIAL: 4130 STEEL PER AMS-T-6736, .324" OD.
- 4 FINISH: PRIME IAW MIL-P-2337J TYPE I CLASS N; 1-2 MIL MAX
- 5 DEBURR AND BREAK ALL SHARP EDGES
- 6 IDENTIFY IAW MPP-120.
- 7 WELD IAW MIL-STD-2219. TIG WELD WITH FILLER ROD
- 8 FINISH: CAD PLATE IAW MIL-C-5541 CLASS 1A
- 9 MASK THREAD PRIOR TO FINISH

REVISIONS			
REV.	DESCRIPTION	DATE	APPROVED
1	LAST PROTOTYPE REVISION: P02		N/C
2	INITIAL RELEASE	12/03/09	P. BRAVO
3	INCORPORATED FCN 04741	11/13/14	P. BRAVO



1			5	647.7714	STRUT TUBE	△	
1	1	1	4	647.7713	STRUT THREAD	△	△
1	1	1	3	647.7712	STRUT TUBE	△	
	1		2	647.7711	STRUT TUBE	△	
		1	1	647.7710	STRUT TUBE	△	
				647.7703	STRUT ASSY		△△
				647.7702	STRUT ASSY		△△
				647.7701	STRUT ASSY		△△
7703	7702	7701	FIND #	PART #	DESCRIPTION	MAT'L	SPEC.
QTY				PARTS LIST			
NEXT ASSY (S)				APICAL INDUSTRIES			
647.7300				2608 TEMPLE HEIGHTS DR.			
646.4000				OCEANSIDE, CA. 92056-3512 (760)724-5300			
ORIGINAL DATE 11/03/09				STRUT ASSY			
DRAWN BY J. JACKSON				SEE CAGE CODE			
DRAWING APPROVAL P. BRAVO				DWG. NO.			
CONTRACT NO.				SCALE NONE			
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 2 PLACE DECIMALS ±.01 3 PLACE DECIMALS ±.005 ANGLES ± .5°				SHEET 1 OF 2			

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1/4 - 28 THREAD

ORIGINAL DATE 12/20/2011 11/03/2011		APICAL INDUSTRIES	
DRAWN BY J. JACKSON		2608 TEMPLE HEIGHTS DR.	
CHECKED BY D. BARKER		OCEANSIDE, CA. 92056-3512 (760)724-5300	
DRAWING APPROVAL P. BRAVO		STRUT ASSY	
CONTRACT NO.		DWG. NO. 647.7700	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 2 PLACE DECIMALS ±.01 3 PLACE DECIMALS ±.005 ANGLES ±.5°		SHEET 07M16	REV. A
		SCALE NONE	SHEET 2 OF 2



2455, Halpern, Saint-Laurent, QUÉBEC, H4S 1N9
Tel.: (514) 335-3666 Fax.: (514) 335-3868
Internet : www.groupaltech.com

**Bon de livraison / Packing Slip
et / and
Certificat de conformité / Certificate of Compliance**

Bon-Livraison / Pk.Slip # : 112147-1 03/09/2015
Bon-Commande. / W.Order # : 112147
Client P.O. # : 29626
Transport :

Envoyé à / Ship to

DART AEROSPACE LTD
1270 ABERDEEN STREET
HAWKESBURY
ONTARIO, CANADA K6A 1K7

Commandé par / Order by

DART AEROSPACE LTD (1427)
1270 ABERDEEN STREET
HAWKESBURY
ONTARIO, CANADA K6A 1K7

#	<u>No. Job</u> <u>No. Réf</u>	<u>NoSerie / Part Number</u> <u>Nom Produit / Product</u>	<u>Traitement</u> <u>Process</u>	<u>Poids</u> <u>Weight</u>	<u>Qté</u> <u>Qty</u>	<u>Envoyé</u> <u>Sent</u>	<u>A venir</u> <u>BO</u>
1	UNIT	647.7703 Rev.	CADMIUM YELLOW PER QQ-P-416F TY:2 CL:1	0.00	10 /	10	0
2	LOT	647.7703 Rev.	HYDROGEN ENBRITAMENT RELIEF (BAKE)	0.00	10	10	0

15/9/14
sl

Notes Additionnelles / Additional Notes

Epaisseur réelle
Actual Thickness

Inspecteur Qualité
Quality Inspector

AD

Réçu par
Received By

Nous certifions que les pièces énumérées ci-dessus ont été traitées en conformité avec votre commande et vos spécifications et rencontrent les exigences.
Notre responsabilité financière et légale ne sera pas supérieure au montant de la facture issue.

We hereby certify that the parts listed above have been process in accordance with your purchase order and specifications and are in conformance with your requirements.
Our financial and legal responsibility will not be higher than the amount of invoice.